

**Work Order ID 72119**

Tuesday, July 19, 2011 12:38:49 PM



Page 1

Item ID: K591-113

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Step Instn Kit

Start Date: 7/19/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

*H*

Date: 11-07-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9525	A								
104	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
105	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
110	Identify as per dwg & Stock Location: 7/380	0.00							
Packaging	Memo	0.00							
Packaging	***CHG005***								

*JB* *11/07/27**Sulos12**(710)*  
*@ 449005**Per 11/12* *(10)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: K591-113

Accept

Setup Start

Revision ID:

Stop

Item Name: Short Step Instln Kit

Start Date: 7/19/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CR 11/08/12

ME 11-08-12

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 72119

Parent Item: K591-113

Parent Item Name: Short Step Instln Kit

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP : C 04.11.09 Reformat KJ/JLM  
as per revG DD 10.04.20 verified by:EC  
586 10.06.18 DD verf:EC  
IPP Rev:D  
IPP Rev:E as per ECN10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2171 Clamp		Manufactured	No			104	Each	43.0000	2	20	✓		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST456				43					
					68938			43		68938			
D2274 Radius Block		Manufactured	No			104	Each	479.0000	4	40	✓		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST010				479					
					68942			179		68942			
					69736			200					
					69773			100					
D2182B Rubber Cushion		Manufactured	No			104	f	192.7852	0.5833	5.833	✓		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST410				192.78517					
					66063			192.78517		66063			

(D2182B035) CUT 2 AT 3.50"

measured  
6/20/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 72119

Parent Item: K591-113

Parent Item Name: Short Step Instln Kit

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 10.00

Required Qty: 10.00

D2362-3

Manufactured No

104 Each

11.0000

1

10



Support Bracket



7257 JB

*[Handwritten signature]*

Location

Loc Qty

Loc Code

ST484

11

68974

11

68974 X9

D3595-200-300

Manufactured No

104 Each

76.0000

1

10



RUBBER CUSHION



JB *[Handwritten signature]*

Location

Loc Qty

Loc Code

ST416

76

41360

76

41360

AN3-37A

Purchased No

104 Each

217.0000

2

20



Bolt



JB *[Handwritten signature]*

Location

Loc Qty

Loc Code

ST353

167

105425

31

111668

136

ST354

50

117619

50

105425

AN4-21A

Purchased No

104 Each

47.0000

4

40



Bolt



JB 11/07/27 *[Handwritten signature]*

Location

Loc Qty

Loc Code

ST359

47

117514

47

117514

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Work Order ID: 72119

Parent Item: K591-113

Parent Item Name: Short Step Instln Kit

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 10.00

Required Qty: 10.00

AN4-22A Purchased No



Bolt

104 Each 163.0000 1 10 ✓



JB L

## Location

## Loc Qty

## Loc Code

ST359

163

114784

15

116419

49

117313

99

114784x6

117313x4

AN960JD10 NAS1149D0363J Purchased No



Washer

104 Each 0.0000 4



40 ✓

117505 JB L

AN960JD416 NAS1149D0463J Purchased No



Washer

104 Each 0.0000 6



60 ✓

118179 JB L

MS21042L3 Purchased No



Nut

104 Each 1,612.000 2



20 ✓

JB L

## Location

## Loc Qty

## Loc Code

ST300

1612

117441

780

117601

400

117885

432

117441

MS21042L4 Purchased No



Nut

104 Each 3,764.000 5



50 ✓

JB 11/07/27

## Location

## Loc Qty

## Loc Code

ST300

3764

117441

1517

117601

747

117885

1500

117441

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Inspector	QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3

REF TCCA STC: SH92-6

REF FAA STC: SH967NE

REFERENCE ONLY

## PURPOSE:

TO PROVIDE AN OPTIONAL CUSHION KIT TO BE INSTALLED ON THE D350-591-111A/-113/-115/-117A/-119 *Heli-Access-Step™* (THE D2856-400-720 ABRASION STRIP IS REPLACED WITH THE D3595-200-300 CUSHION).

## CHANGE:

FOR D350-591-111A/-113/-115 @ CHG 005 (OR LATER), D350-591-117A @ CHG 003 (OR LATER) AND D350-591-119 @ CHG 004 (OR LATER), THE PARTS LIST OF INSTALLATION INSTRUCTIONS D350-591 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 IS AMENDED AS FOLLOWS:






QTY -111A	QTY -113	QTY -115	QTY -117A	QTY -119	Part Number	Description
X					D350-591-111A	Heli-Access-Step™, Long Step – High Skid
	X				D350-591-113	Heli-Access-Step™, Short Step – High Skid
		X			D350-591-115	Heli-Access-Step™, Short Step – Low Skid
			X		D350-591-117A	Heli-Access-Step™, Pre-Flight Step
				X	D350-591-119	Heli-Access-Step™, Long Step – Low Skid
	1				D2310	STEP ASSEMBLY (HIGH-SHORT)
1					D2311	STEP ASSEMBLY (HIGH-LONG)
		1			D2354	STEP ASSEMBLY (LOW-SHORT)
				1	D2355	STEP ASSEMBLY (LOW-LONG)
4	2	2	2	2	D2171	CLAMP
4	2	2	2	2	D2182B035	CUSHION
8	4	4	4	4	D2274	RADIUS BLOCK
			1		D2362-041	SUPPORT BRACKET
2	1			1	D2362-3	SUPPORT BRACKET
		1			D2362-5	SUPPORT BRACKET
2	1	1	1	1	D3595-200-300	CUSHION (NEW)
2	2	2		2	AN3-37A	BOLT
		4			AN4-20A	BOLT (REPLACED, WAS AN4-16A)
8	4			4	AN4-21A	BOLT (REPLACED, WAS AN4-20A)
1	1	1	4	1	AN4-22A	BOLT
4	4	4		4	NAS1149D0363J	WASHER (OR AN960JD10)
10	6	2	4	6	NAS1149D0463J	WASHER (OR AN960JD416)
		4			NAS1149D0416J	WASHER (OR AN960JD416L)
2	2	2		2	MS21042L3	NUT
9	5	5	4	5	MS21042L4	NUT

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-0-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 10.06.08  
CERT. NO.: SH92-6  
ISSUE NO.: 11

A	NEW ISSUE.	JPH	10.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STEP CUSHION CHANGE	NTS
DATE	10.06.08	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	